



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**649.4902**  
**Job Sheet 212426**



DAS  
21  
9-89

**Part No:** 649.4902

**Job Qty:** 6 pcs

**Part Name:** Lower Cutter Assembly



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 8/24/20

**Job Tracking No:**

**Due Date:** 9/14/20

**Created By:** Marie Lajeunesse

**Type:** SOLD

**Description:**

**Note:** DWG REV A IPP REV:A 12.11.01 NEW ISSUE DD VERF:JLM

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                        |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 110   | Packaging 1 - Pick Kit | 6 pcs |            | 9/12/20  | 0.00      | 0.00    | Packaging 1 - 1       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 2       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 3       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 4       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 5       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 6       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 7       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 8       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 9       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 10      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 11      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 12      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 13      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 14      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 15      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 16      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 17      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 18      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 19      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 20      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 21      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 22      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 23      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 24      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 25      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 26      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 27      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 28      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 29      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 30      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 31      |           |          |

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|     |                             |   |         |                  |                             |
|-----|-----------------------------|---|---------|------------------|-----------------------------|
|     |                             |   |         | Packaging 1 - 32 |                             |
|     |                             |   |         | Packaging 1 - 33 |                             |
|     |                             |   |         | Packaging 1 - 34 |                             |
|     |                             |   |         | Packaging 1 - 35 |                             |
|     |                             |   |         | Packaging 1 - 36 |                             |
|     |                             |   |         | Packaging 1 - 37 |                             |
| 120 | Small Fab - 2 - B4B         | 6 | 9/14/20 | 0.00 0.15        | Small Fab - 1 - B4B         |
|     | pcs                         |   |         |                  | Small Fab - 2 - B4B         |
|     |                             |   |         |                  | Small Fab - 3 - B4B         |
|     |                             |   |         |                  | Small Fab - 4 - B4B         |
|     |                             |   |         |                  | Small Fab - 5 - B4B         |
|     |                             |   |         |                  | Small Fab - 6 - B4B         |
|     |                             |   |         |                  | Small Fab - 7 - B4B         |
|     |                             |   |         |                  | Small Fab - 8 - B4B         |
|     |                             |   |         |                  | Small Fab - 9 - B4B         |
|     |                             |   |         |                  | Small Fab - Various 1 - B4B |
| 130 | QC 5                        | 6 | 9/14/20 | 0.00 0.00        | QC 5 - 10                   |
|     | pcs                         |   |         |                  | QC 5 - 12                   |
|     |                             |   |         |                  | QC 5 - 17                   |
|     |                             |   |         |                  | QC 5 - 18                   |
|     |                             |   |         |                  | QC 5 - 19                   |
|     |                             |   |         |                  | QC 5 - 22                   |
|     |                             |   |         |                  | QC 5 - 24                   |
|     |                             |   |         |                  | QC 5 - 3                    |
|     |                             |   |         |                  | QC 5 - 43                   |
|     |                             |   |         |                  | QC 5 - 49                   |
|     |                             |   |         |                  | QC 5 - 51                   |
|     |                             |   |         |                  | QC 5 - 58                   |
|     |                             |   |         |                  | QC 5 - 68                   |
|     |                             |   |         |                  | QC 5 - 9                    |
|     |                             |   |         |                  | QC 5 - 50                   |
|     |                             |   |         |                  | QC 5 - 30                   |
|     |                             |   |         |                  | QC 5 - 40                   |
|     |                             |   |         |                  | QC 5 - 61                   |
|     |                             |   |         |                  | QC 5 - 81                   |
|     |                             |   |         |                  | QC 5 - 82                   |
| 140 | Packaging 3-1 - Stock - B4B | 6 | 9/14/20 | 0.00 0.00        | Packaging 3 - 1 - B4B       |
|     | pcs                         |   |         |                  | Packaging 3 - 2 - B4B       |
|     |                             |   |         |                  | Packaging 3 - 3 - B4B       |
|     |                             |   |         |                  | Packaging 3 - 4 - B4B       |
|     |                             |   |         |                  | Packaging 3 - 5 - B4B       |
|     |                             |   |         |                  | Packaging 3 - 6 - B4B       |
|     |                             |   |         |                  | Packaging 3 - 7 - B4B       |
|     |                             |   |         |                  | Packaging 3 - 8 - B4B       |
|     |                             |   |         |                  | Packaging 3 - 9 - B4B       |
|     |                             |   |         |                  | Packaging 3 - 10 - B4B      |
|     |                             |   |         |                  | Packaging 3 - 11 - B4B      |
|     |                             |   |         |                  | Packaging 3 - 12 - B4B      |
|     |                             |   |         |                  | Packaging 3 - 13 - B4B      |
|     |                             |   |         |                  | Packaging 3 - 14 - B4B      |
|     |                             |   |         |                  | Packaging 3 - 15 - B4B      |
|     |                             |   |         |                  | Packaging 3 - 16 - B4B      |
|     |                             |   |         |                  | Packaging 3 - 17 - B4B      |
|     |                             |   |         |                  | Packaging 3 - 18 - B4B      |
|     |                             |   |         |                  | Packaging 3 - 19 - B4B      |
|     |                             |   |         |                  | Packaging 3 - 20 - B4B      |
|     |                             |   |         |                  | Packaging 3 - 21 - B4B      |
|     |                             |   |         |                  | Packaging 3 - 22 - B4B      |

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|     |            |     |         |                        |                 |
|-----|------------|-----|---------|------------------------|-----------------|
|     |            |     |         | Packaging 3 - 23 - B4B |                 |
|     |            |     |         | Packaging 3 - 24 - B4B |                 |
|     |            |     |         | Packaging 3 - 25 - B4B |                 |
|     |            |     |         | Packaging 3 - 26 - B4B |                 |
|     |            |     |         | Packaging 3 - 27 - B4B |                 |
|     |            |     |         | Packaging 3 - 28 - B4B |                 |
|     |            |     |         | Packaging 3 - 29 - B4B |                 |
|     |            |     |         | Packaging 3 - 30 - B4B |                 |
|     |            |     |         | Packaging 3 - 31 - B4B |                 |
|     |            |     |         | Packaging 3 - 32 - B4B |                 |
|     |            |     |         | Packaging 3 - 33 - B4B |                 |
|     |            |     |         | Packaging 3 - 34 - B4B |                 |
|     |            |     |         | Packaging 3 - 35 - B4B |                 |
|     |            |     |         | Packaging 3 - 36 - B4B |                 |
|     |            |     |         | Packaging 3 - 37 - B4B |                 |
| 150 | QC 21 - SA | 6   | 9/14/20 | 0.00 0.00              | QC 21 - SA - 21 |
|     |            | pcs |         |                        | QC 21 - SA - 70 |
|     |            |     |         |                        | QC 21 - SA - 9  |
|     |            |     |         |                        | QC 21 - SA - 77 |

Part Op 110 - (Pick Kit)

Descriptions: 120 - (Small Fab) Assemble as per dwg Apply RTV TO ALL FAYING SURFACES RTV 598 BATCH: 5286901  
 130 - (QC5- Inspect part completeness to step on W/O)  
 140 - (Identify as per dwg & Stock Location: \_\_\_\_\_) \*\*\*IDENTIFY AS DWG PER APICAL MPP-120 BY LASER ETCH THE P# AND REV\*\*\*  
 150 - (QC21- Final Inspection - Work Order Release)

OTD

## Job BOM

| Part / Item   | Component Name           | Quantity        | Operation                  | Container |
|---------------|--------------------------|-----------------|----------------------------|-----------|
| 649.5301      | Lower Deflector Assembly | 4 6 pcs (1 ea)  | 110-Packaging 1 - Pick Kit | 5210500   |
| 649.8301      | Cutter Sub Assembly      | 4 6 pcs (1 ea)  | 110-Packaging 1 - Pick Kit | 5210500   |
| MS21042L08    | Nut                      | 12 18 Ea (3 ea) | 110-Packaging 1 - Pick Kit | 5210500   |
| MS27039-08-19 | Screw                    | 12 18 Ea (3 ea) | 110-Packaging 1 - Pick Kit | 5210500   |
| NAS1149FN832P | Washer (AN960-8 )        | 24 36 Ea (6 ea) | 110-Packaging 1 - Pick Kit | 5210500   |

## Job Allocations

| Operation                  | Component Part | Required | Inventory | Allocated |
|----------------------------|----------------|----------|-----------|-----------|
| 110-Packaging 1 - Pick Kit | 649.5301       | 6        | 5         | 0         |
|                            | 649.8301       | 6        | 0         | 0         |
|                            | MS21042L08     | 18       | 790       | 0         |
|                            | MS27039-08-19  | 18       | 726       | 0         |
|                            | NAS1149FN832P  | 36       | 1,239     | 0         |

## Part Specifications

Specifications could not be found.

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

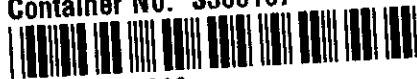
NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                        |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  | MRB (QS1042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | QC / QA Coordinator    |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |



Container No: S300107



Part: 649.4902

Job No: 212426

Serial No/Batch: S300107

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 813 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Date: 09/14/20